

FIG.1A

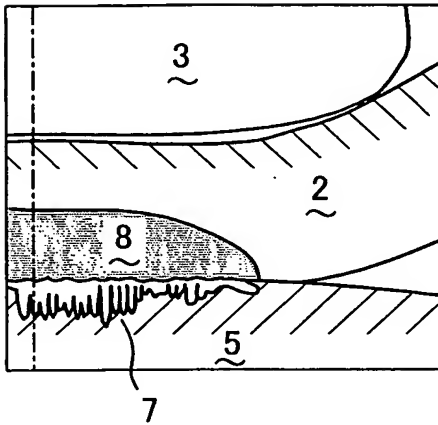


FIG.1B

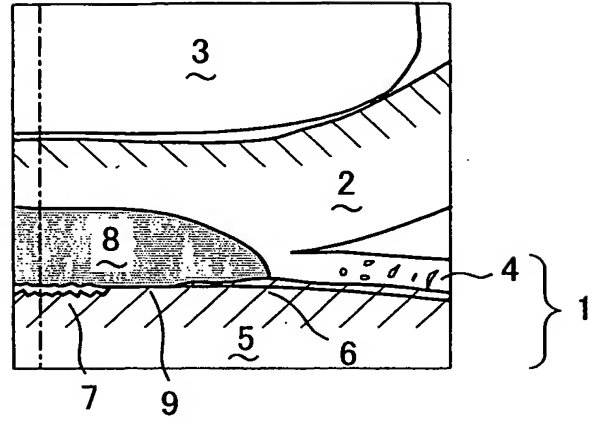


FIG.2

| weld cycle time | peripheries of nuggets | centers of nuggets |
|-----------------|------------------------------|------------------------------|
| 1 | <div>Si:3.1%, Fe:35.6%</div> | <div>Si:1.7%, Fe:37.6%</div> |
| 3 | | <div>Si:0.9%, Fe:40.8%</div> |
| 6 | | <div>Si:0.8%, Fe:46.0%</div> |

1 μ m

FIG.3

